

Work Order ID 60639

Thursday, July 15, 2010 10:35:42 AM



Page 1

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 7/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-7-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14 ☐ Coat all hardware with LPS3 rust inhibitor ☐ A/R LPS3 batch: M110259 ☐ COAT exposed HARDWARE WITH LPS PROCYON ☐ A/R LPS PROCYON BATCH: M114596

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date: 8/5/09/01 (2)

Handwritten signature and date: 2 100901
FD'd AS -034 for PKing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/9/25

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2 Kits separated & I'd'd

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-034

Location: _____

PPP Rev: _____

10/9/25

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/14
NF
10-9-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli Access Step RH Folding




Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8  Nut		Purchased	No				Each	39.0000	2	4		7/10/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				39					
				109148				5					
				111279				4					
				111819				30					
AN3C21A  BOLT		Purchased	No				Each	64.0000	2	4		7/10/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST352				64					
				109148				64					
AN44C7A  Eyebolt		Purchased	No				Each	92.0000	1	2		7/19/10	2x
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST362				92					
				109013				47					
				111279				3					
				111308				40					
				111503				2					

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli Access Step RH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00



Purchased No

Each 120.0000

1

2



10/9/2sf

Location

Loc Qty

Loc Code

ST356

120

106302

5

111295

35

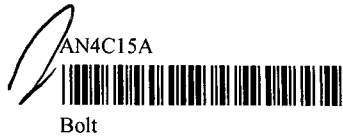
112243

50

114523

30

2



Purchased No

Each 124.0000

2

4



10/9/2sf

Location

Loc Qty

Loc Code

ST358

124

111819

1

113595

11

113603

10

114330

2

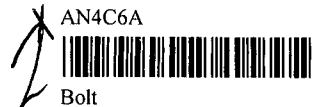
114442

50

114523

50

4



Purchased No

Each 451.0000

1

2



1111295 10/9/2sf

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

447

113121

247

115016

200

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

AN5C15A
Bolt

Purchased No

Each 93.0000

2 4



10/19/2010

Location

Loc Qty

Loc Code

ST339

93

111819

93

Purchased No

Each 83.0000

2 4



6/10/09/01

Location

Loc Qty

Loc Code

ST345

83

105969

23

106066

60

Manufactured No

Each 25.0000

1 2



6/10/09/01

Location

Loc Qty

Loc Code

ST004

25

40274

7

46634

18

Manufactured No

Each 2.0000

1 2



6/10/09/01

Location

Loc Qty

Loc Code

ST149

2

46330

2

AN5C15A

Bolt

AN8C16

Bolt

D2012-107

Clevis

D2803-042

Bracket Assembly

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Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60639

Parent Item: D412-630-034


Parent Item Name: Heli Access Step RH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

D2804-042

 Bracket Assembly

Manufactured No

Each 3.0000

1


2
 EP 5/0/09/01

Location

Loc Qty

Loc Code

ST150

3

46640

3

Each

27.0000

2


2
 10/9/12 SL

D2806-1

 Bushing

Manufactured No

Location

Loc Qty

Loc Code

ST025

27

14080

2

46609

25

Each

27.0000

2


4
 10/9/12 SL

D2806-3

 Bushing

Manufactured No

Location

Loc Qty

Loc Code

ST025

27

46737

27

Each

11.0000

2


4
 EP 5/0/09/01

D2807-041

 Door prop

Manufactured No

Location

Loc Qty

Loc Code

ST025

11

55108

1

56882

10

1
 3

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Page 4

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 60639

Parent Item: D412-630-034

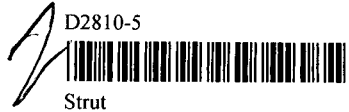
Parent Item Name: Heli Access Step RH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

 D2810-5
Strut

Manufactured No

Each 10.0000



1 2
10/9/25

Location

Loc Qty

Loc Code

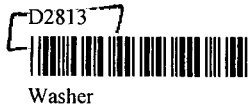
ST265

10

52034

10

2

 D2813
Washer

Manufactured No

Each 23.0000



2 4
E 5/10/09/01

Location

Loc Qty

Loc Code

ST025

23

14401

11

46332

12

4

 D3395-1
Bushing

Manufactured No

Each 20.0000



4 8
E 5/10/09/01

Location

Loc Qty

Loc Code

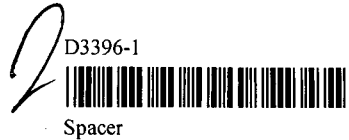
ST055

20

46616

20

9

 D3396-1
Spacer

Manufactured No

Each 56.0000



2 4
10/9/25

Location

Loc Qty

Loc Code

ST055

56

46748

56

4

 D3562-042
Step Assembly, RH

Manufactured No

Each 1.0000



1
E 5/10/09/01

Location

Loc Qty

Loc Code

FG110

1

54964

1

B60889 (200)

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Page 5

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 60639

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS21043-3



Nut

Purchased

No

Each

3,047.000

4

8



EP 10/08/01

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2971

112314

2971

8

MS21043-4



Nut

Purchased

No

Each

1,283.000

4

8



10/9/01

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1243

112492

25

113069

8

114348

410

114523

500

114784

300

8

MS21043-5



Nut

Purchased

No

Each

612.0000

3

6



M110180 (2x) M111819 (4x) 10/9/12

Location

Loc Qty

Loc Code

ST301

612

111819

112

112314

500

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Work Order ID: 60639

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS24665-302

Purchased

No

Each

53.0000

2

4



Cotter Pin

Location

Loc Qty

Loc Code

ST309

53

113644

53

Each

27.0000

2

4

MS24693-C280

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST318

27

111279

27

Each

136.0000

6

12

NAS1515H3

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST277

136

111268

136

Each

139.0000

7

14

NAS1515H4

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST277

139

111294

41

111525

98

12x
2x

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Parent Item Name: Heli Access Step RH Folding

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1515H5
Washer

Purchased No

Each

241.0000

7

14

10/19/25

Location

Loc Qty

Loc Code

FG

44

103286

17

103691

27

ST277

197

109430

197

Each

156.0000

4

8

8/10/09/01

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

116

108964

16

111359

100

Each

338.0000

4

8

8/10/09/01

Location

Loc Qty

Loc Code

ST278

338

111275

138

111411

200

8

NAS1515H5L

WASHER

Purchased No

NAS1515H8

Washer

Purchased No

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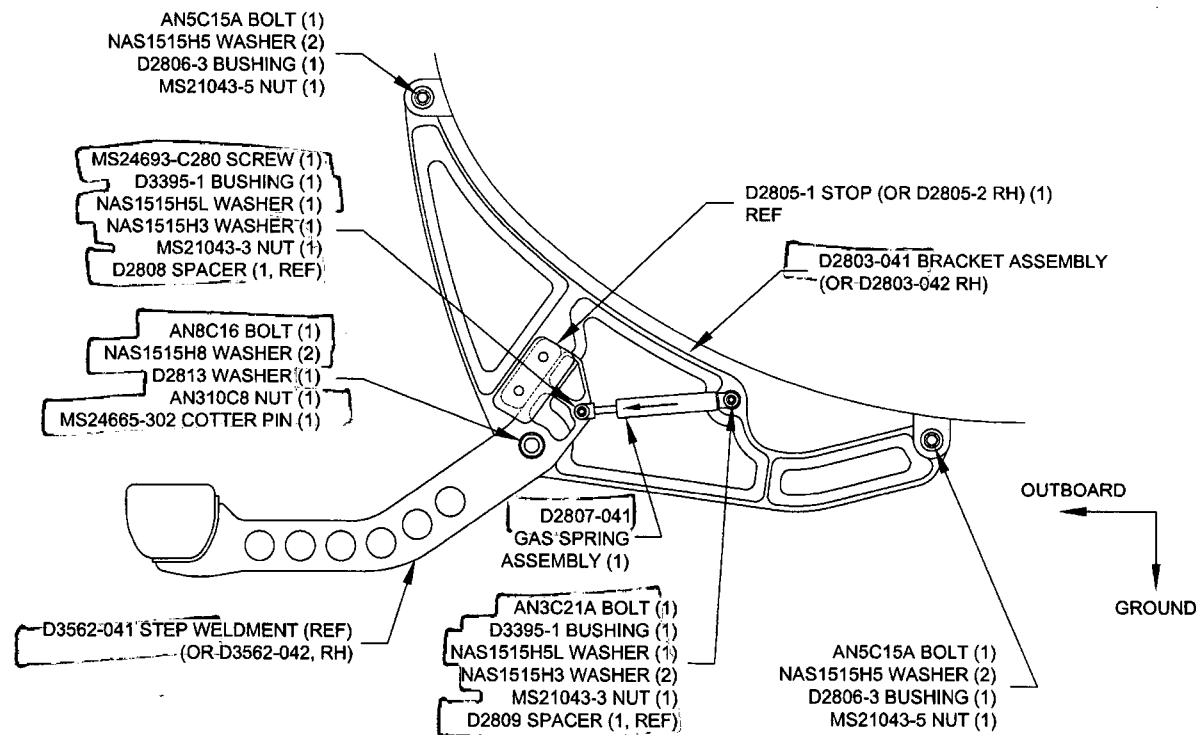
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D412-630-033/-034 Heli-Access-Step™ Installation



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60639
R/KO-710

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

AN4C15A BOLT (1)
NAS1515H4 WASHER (2)
D2806-1 BUSHING (1)
MS21043-4 NUT (1)

D2805-1 STOP (OR D2805-2 RH) (1)
AN3C16A BOLT (2)

W/O:		WORK ORDER CHANGES					
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